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Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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RBW6505G00831-3G
Job Sheet 186619



Part No: RBW6505G00831-3G

Job Qty: 2 ea

Part Name: Tail Rotor Gear Box Support Trolley Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/19/18

Job Tracking No:

Due Date: 11/29/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG RBW6505G00831-3G Rev2 IPP Rev A 17.11.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	11/29/18	11/29/18	0.00	0.00	Start Up Small Fab-4		MLL
110	Small Fab	2 pcs	11/29/18	11/29/18	0.00	2.00	Small Fab-8		DAS
120	QC	2 pcs	11/29/18	11/29/18	0.00	0.00	QC5		NOV 22 2018 68
130	Packaging	2 pcs	11/29/18	11/29/18	0.00	0.00	Packaging3-1		9-89
140	QC21-FG	2 Ea	11/29/18	11/29/18	0.00	0.00	QC21		NOV 23 2018

Part Op 90 - DWG needs engineering sign off for Ferrule 3896t31 and cable CL-2-C
Descriptions: 110 - Assemble as per DWG. Sheet 1 & 2

MLL
NOV 22 2018

DAS
21
9-89

NOV 23 2018



Container No: S130560



Part: RBW6505G00831 - 3G

Job No: 186619

Serial No/Batch: S130560

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 11/22/18

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2005 11 18 10:00

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SAC

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	12 Ea (6 ea)	90-Start up Operation	5122137
63 90177A219	Split Ring	12 Ea (6 ea)	90-Start up Operation	5015388
66 90949A016	Locknut	4 Ea (2 ea)	90-Start up Operation	5015389
68 91251A421	Socket Head Cap Screw	4 Ea (2 ea)	90-Start up Operation	5037411
68 91251A426	Socket Head Cap Screw	4 Ea (2 ea)	90-Start up Operation	5015390
70 91259A583	Shoulder Screw 5/16" Shoulder Dia, 1" L Shoulder, 1/4"-20 Thread	4 Ea (2 ea)	90-Start up Operation	5068316
52 91654A076	Drive Screw #2 3/16" Long	8 Ea (4 ea)	90-Start up Operation	5015391
55 92620A540	Hex Head Cap Screw	8 Ea (4 ea)	90-Start up Operation	5084062
57 94744A240	Flat Washer	8 Ea (4 ea)	90-Start up Operation	5015393
38 95395A226	Washer	4 Ea (2 ea)	90-Start up Operation	5070278
40 98099A031	Washer	4 Ea (2 ea)	90-Start up Operation	5126475
CL-2-C	Lanyard Wire	5 ft (2.5 ea)	90-Start up Operation	5093863
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	90-Start up Operation	5021040
143F RBW6505G00831-3G-1	Leg Assembly Weldment	2 Ea (1 ea)	90-Start up Operation	5122201
98 RBW6505G00831-3G-19	Swivel Base	2 Ea (1 ea)	90-Start up Operation	5088458
97 RBW6505G00831-3G-21	Swivel Plate	2 Ea (1 ea)	90-Start up Operation	508558
98 RBW6505G00831-3G-23	Bar	2 Ea (1 ea)	90-Start up Operation	5080855
98-99 RBW6505G00831-3G-25	Mount Plate	2 Ea (1 ea)	90-Start up Operation	5026914
97 RBW6505G00831-3G-41	Pin	6 Ea (3 ea)	90-Start up Operation	5128407
148F RBW6505G00831-3G-7	Swivel Plate Weldment	2 Ea (1 ea)	90-Start up Operation	5122209

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	12	586	0
	90177A219	12	26	0
	90949A016	4	92	0
	91251A421	4	12	0
	91251A426	4	17	0
	91259A583	4	4	0
	91654A076	8	68	0
	92620A540	8	183	0
	94744A240	8	9	0
	95395A226	4	7	0
	98099A031	4	22	0
	CL-2-C	5	501	0
	RB41011	2	702	0
	RBW6505G00831-3G-1	2	2	0
	RBW6505G00831-3G-19	2	5	0
	RBW6505G00831-3G-21	2	2	0
	RBW6505G00831-3G-23	2	3	0
	RBW6505G00831-3G-25	2	5	0
	RBW6505G00831-3G-41	6	10	0
	RBW6505G00831-3G-7	2	2	0

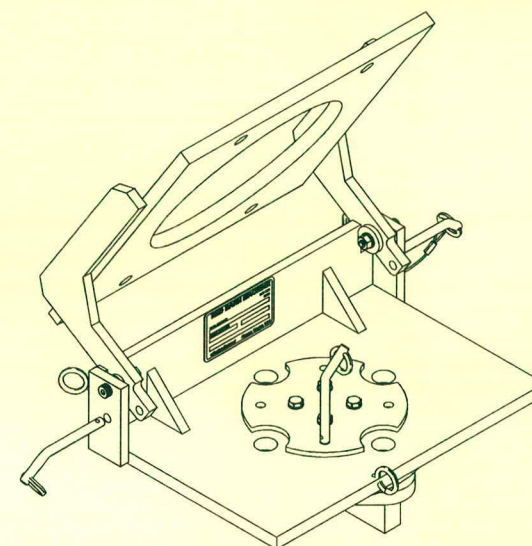
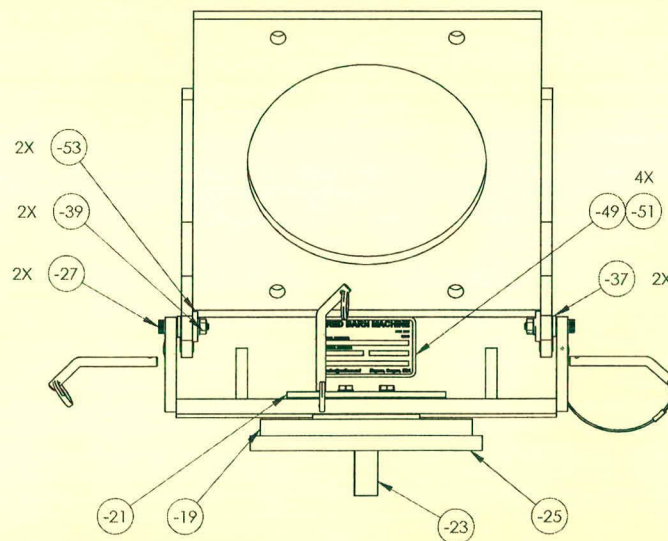
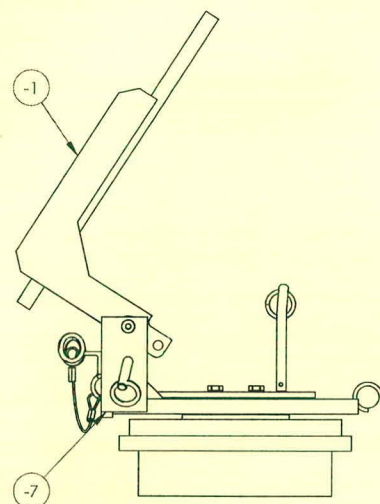
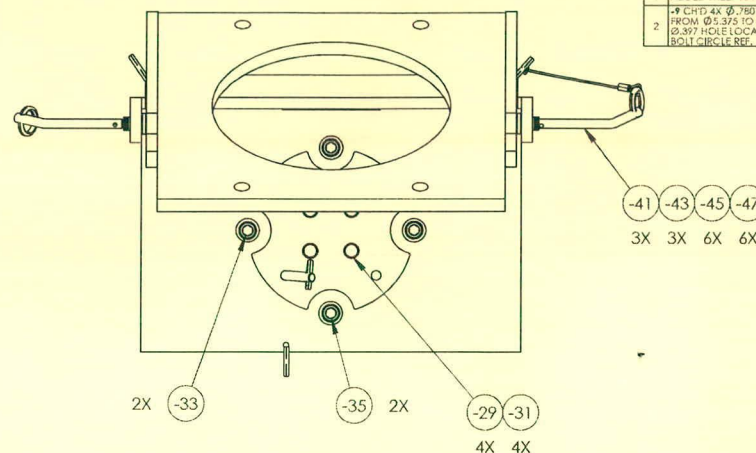
Part Specifications
Specifications could not be found.

Plex 11/19/18 10:35 AM dart.lacelle.linda

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED SHEET 16 FOR -41. SHEET 5 CHD -5 DIMENSION LOCATION WAS 6.255 IS 7.255	5/10/2013	CFS	
2	-9 CHD 4X Ø.760 HOLE B.C. FROM Ø5.375 TO Ø5.512. -19 CHD COUNTER BORED HOLES B.C. FROM Ø5.375 TO Ø5.512. -23 CHD HOLE LOCATIONS FROM 5.38 TO 5.51. -25 CHD 3/8-24 AND Ø.397 HOLE LOCATIONS FROM 2X 1.90 AND 2X 3.60 TO 2X 1.95 AND 2X 3.90 AND ADDED Ø5.512 BOLT CIRCLE REF.	7/12/2013	RJC	RW

TEO ATTACHED



SEE ATTACHED DEVIATION

RED BARN MACHINE	
TITLE TROLLEY ADAPTER, TGB SUPPORT	
DWG NO. RBW6505G00831-3G	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: CLOUGH APPROVED: <i>D. Wood</i> HEAT TREAT FINISH SPEC USED ON MODEL AW139
1. BREAK ALL SHARP EDGES .015 x 45° 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 2/6/2012
SHEET 1 OF 16	

